

Date: Wednesday, 12/7/2005 8:26:11 AM
 User: Kim Johnston

Process Sheet

| | |
|---|--|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : CONSOLE SIDE LH (206 HI-SLOPE) |
| Job Number : 25141 | |
| Estimate Number : 11001 | |
| P.O. Number : N/A | Part Number : D26022 |
| This Issue : 12/7/2005 S.O. No. : N/A | Drawing Number : D2602 REV A1 |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : N/A Type : MACHINED PARTS | Drawing Revision : A1 |
| Previous Run : N/A | Material : N/A |
| Written By : <u>SEE COMMENT BELOW</u> | Due Date : 1/10/2006 Qty: 10 Um: Each |
| Checked & Approved By : <u>SEE COMMENT BELOW</u> | |
| Comment : Est. E 04.02.25 Reformat KJ/RF Note: Issue with part number D2602-1 | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|-------------|--------------------|
| 1.0 | M2024T3S040 | 2024-T3 .040 sheet |
|-----|-------------|--------------------|



Comment: Qty.: 1.4146 sf(s)/Unit Total: 14.1456 sf(s)
 2024-T3 .040 sheet
 Material: 2024-T3 (QQ-A-250/4) 0.040" thick
 (M2024T3S.040) Batch M19059

| | | |
|-----|-------|-------|
| 2.0 | SHEAR | SHEAR |
|-----|-------|-------|



Comment: SHEAR
 Cut Blank per template DT8243

J.L 05-12-16

| | | |
|-----|-------|--------------------------------|
| 3.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
|-----|-------|--------------------------------|



Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio FA145 and Dwg D2602
 Stack of 10
 Identify as D2602-2

J.L 05-12-16

| | | |
|-----|-----|--|
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 05-12-16

| | | |
|-----|-----|--------------|
| 5.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

J.L 05-12-16

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DD Date: 06/01/24
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 12/7/2005 8:26:11 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE SIDE LH (206 HI-SLOPE)

Job Number: 25141

Part Number: D26022

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Deburr

Form as per Dwg D2602

SB 06/01/16 10

SAD 12/18/05 10

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-01-16

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FF 06-01-19

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06-01-20

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

FF 06-01-24

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

545 06/01/24 (10)

10 06/01/24 (10)

Job Completion



| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | |
|---|---------------------|--------------------|
| DART AEROSPACE LTD | Work Order: | 25141 |
| Description: Console Side LH/RH | Part Number: | D2602-1/-2 |
| Inspection Dwg: D2602 Rev: A1 | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

| <input checked="" type="checkbox"/> First Article | <input type="checkbox"/> Prototype |
|---|---|
| <p>1. Introduction</p> <p>2. Materials and Methods</p> <p>3. Results</p> <p>4. Discussion</p> <p>5. Conclusion</p> | <p>1. Introduction</p> <p>2. Materials and Methods</p> <p>3. Results</p> <p>4. Discussion</p> <p>5. Conclusion</p> |

[illegible]

| | | | | | |
|--------------|----------|-------------|--|---------------------|-----|
| Measured by: | TL | Audited by: | | Prototype Approval: | N/A |
| Date: | 05.12.16 | Date: | | Date: | N/A |

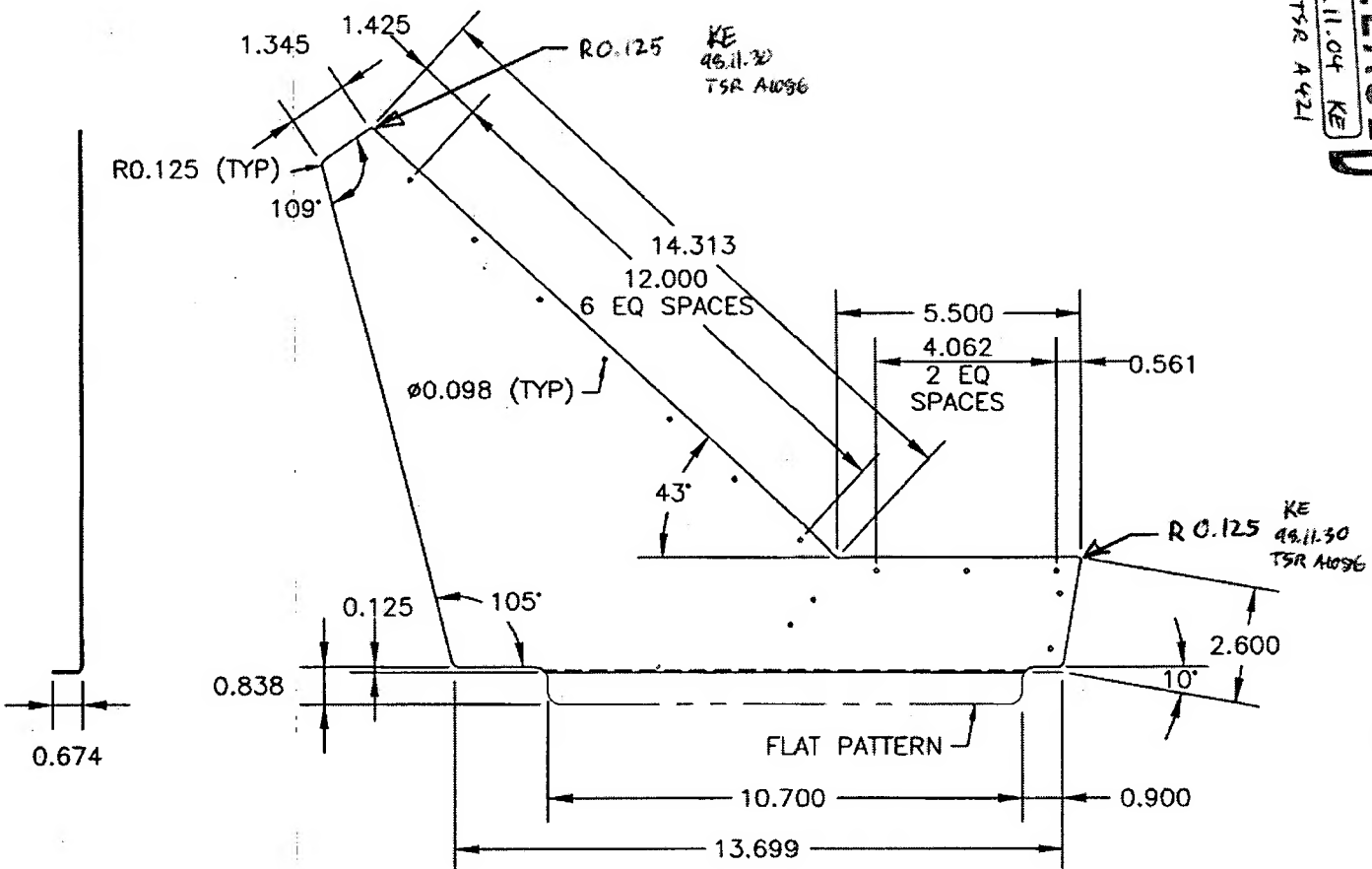
| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A | 04.02.25 | New Issue | KJ/RF | |

DART



| | | | | |
|----------------------|-----------------------|--|--------------|--|
| DESIGN | DRAWN BY | DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA | | |
| CHECKED <i>KE</i> | APPROVED <i>BW</i> | DRAWING NO. | REV. A | |
| DATE 97.10.22 | | D2602 | SHEET 1 OF 1 | |
| | | TITLE CONSOLE SIDE | SCALE 1:4 | |
| A | 97.10.22 | D2602 WAS D206-547-21/ -22 | | |
| AI | 02.06.04 | ADD FINISH | | |

RELEASED
97.11.04 KE
TSR A421



MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK

PROFILE CONTROLLED BY FOLIO H2602

BEND RADIUS 0.093

FINISH: CHEMICAL CONVERSION COAT PER DART QSI 605 4.1 Δ AI

D2602-1 SHOWN

D2602-2 OPPOSITE

25141